

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-018354**Date Inspected:** 20-Nov-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Xu Le Feng, Geng Wei**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG/TOWER**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Umesh Gaikwad was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

This Quality Assurance (QA) Inspector observed the following work in progress:

BAY 14

SEGMENT 13CE

This QA Inspector observed that the R25 cope hole is not provided on the floor beams; of PP122.5 and 123. Welding and NDT (UT) of FB to LD CJP weld at PP122.5 to 123 is completed. ZPMC personnel performing Air Carbon Arc gouging to make cope hole which observed to be sealed by welding. This is informed this to CT Lead QA. See attached photos for further details.

FCAW welding of weld joint 161 located on SEG3070.

Welder is identified as 067949. ZPMC QC is identified as Mr. Zhong Yong Gang.

The welding variables recorded by QC appeared to comply with WPS-B-T-2332-Tc-P4-F.

FCAW welding of weld joint 213 located on SEG3012A.

Welder is identified as 044774. ZPMC QC is identified as Mr. Zhong Yong Gang.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

The welding variables recorded by QC appeared to comply with WPS-B-T-2132.

FCAW welding of weld joint 095 located on SEG3091AB joining LD 3042 to Bottom plate (B-CWR2091, REV 0).

Welder is identified as 044824. ZPMC QC is identified as Mr. Wang Xu.

The welding variables recorded by QC appeared to comply with WPS-345-FCAW-2G(2F)-FCM-REPAIR.

BAY 10

OBG BIKE PATH

FCAW welding of weld joint 013 located on BK004A2-025.

Welder is identified as 052075. ZPMC QC is identified as Mr. Li Jun.

The welding variables recorded by QC appeared to comply with WPS-B-T-2132.

FCAW welding of weld joints 047~050 located on BK004A6-032.

Welder is identified as 053869. ZPMC QC is identified as Mr. Li Jun.

The welding variables recorded by QC appeared to comply with WPS-B-T-2133.

FCAW welding of weld joint 104 & 105 located on BK004A8-032.

Welder is identified as 040533. ZPMC QC is identified as Mr. Li Jun.

The welding variables recorded by QC appeared to comply with WPS-B-T-2132.

SMAW welding of weld joint 183 located on BK007A7-001.

Welder is identified as 053829. ZPMC QC is identified as Mr. Yu Zhi Lai.

The welding variables recorded by QC appeared to comply with WPS-B-P-2113.

BAY 11

TOWER BRACKET REPAIR (T-WR3772)

SMAW welding of weld joint 006A/B located on ND1-BRSA5-2.

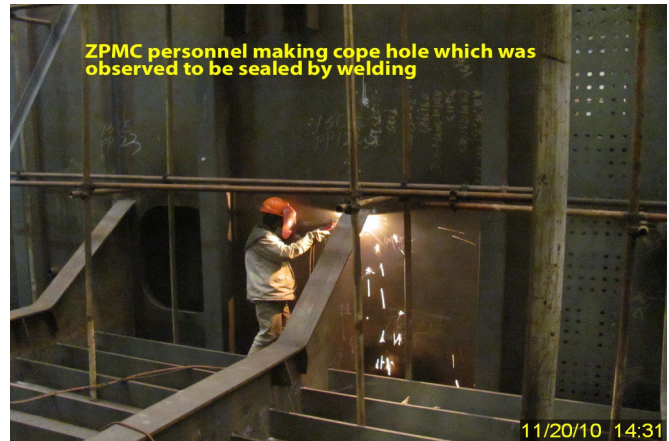
Welder is identified as 044541. ZPMC QC is identified as Mr. Li Bin.

The welding variables recorded by QC appeared to comply with WPS-485-SMAW-2G(2F)-REPAIR-1.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)



Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang : 15000422372/ Thomas Ho - 150002048250, who represents the Office of Structural Materials for your project.

Inspected By:	Gaikwad,Umesh	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer
